

Work Order ID 80421

80421

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February-21-12 9:05:26 AM

Item ID: D3610-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 21/02/2012 Start Qty: 8.00 *16* w *8*
 Required Date: 06/03/2012 Req'd Qty: 8.00 *8*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: *M.L.J* Date: *12/02/21* Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3610	Rev A

100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 6.600 " long								

110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA692 Rev: <i>AA</i> & Dwg D3610 Rev: <i>A</i> 2-Deburr per dwg D3610								

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

(PTB)

W/O: 80421		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3610-041 PAR #: _____ Fault Category: Machinis NCR: Yes No DQA: AK Date: 12/04/09
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: ck Date: 12/4/11

NCR: 12-1321		WORK ORDER NON-CONFORMANCE (NCR) 111.96						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/01	110	put part in the wrong direction. R.L. operator error	S 12/04/02 Q51042	scrap and destroy replace Qty: 1 Batch <u>M119871</u>	anf 12/04/02	S 12/04/02	S 12/04/02 Q51042	S 12/04/02
			anf 12/04/11 Q51042				anf 12/04/11 Q51042	

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		2L 12/04/12					
140 *140* Small Fab Small Fab	Small Fab Memo 1-C'SINK AS PER DWG D3610	0.00 0.00							EP 12/04/12 (16)
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/21/13					(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160						16	8	(2P)	12/04/03.
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9h20	OVEN TEMPERATURE: m117338							
	9h50 FINISH TIME: 320°F								
170	QC3- Inspect Part Finish	0.00							
170						16	HL D 4-3.		
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Rivet Nut Plate as per Dwg D3610								

16 12/04/03 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							4/6
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: 245A Memo	0.00 0.00							12/4/354 (16)
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MCS 12/04/03

R12-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-21-12 9:05:30 AM

Page 1

Work Order ID: 80421

80421

Parent Item: D3610-041

D3610-041

Parent Item Name: Bracket

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A new issue 07.03.28 EC
IPP rev B released, changed mat'l EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4140N- B1.500X1.5000		Purchased	No			100	f	11.4000	0.5775	4.62			

M4140N-B1 500X1 5000

4140 Steel Bar 1.50 x 1.50

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	MAT034	11.4	
	→ 119871	11.4	
MS20426AD3-4		110	Each
		4,006.000	2

MS20426AD3-4

RIVET

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST316	4006	
	104374	1024	
	110398	2982	
MS21075L3		180	Each
		177.0000	1

MS21075L3

Nutplate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST303	177	
120459	177	

9.71 02/12/03/21
E/S 12/04/03
32
8
E/S 12/04/03
11/20/10
16x

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80421
Description: Plate		Part Number:	D3610-1
Inspection Dwg: D3610 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.250	—		Vernier	
0.250	+/-0.010	.250	—			
0.63	+/-0.030	.623	—			
6.50	+/-0.030	6.503	—			
3.00	+/-0.030	3.000	—			
2.677	+/-0.010	2.677	—			
0.38	+/-0.030	.372	—			
Ø.277	+0.006/-0.001	Ø.278	—			
Ø.201	+0.005/-0.001	Ø.202	—			
Ø.098	+0.004/-0.001	Ø.098	—			
0.88	+/-0.030	.877	—			
0.94 x 0.50	+/-0.030	.937 x .500	—			
0.250	+/-0.010	.257	—			
0.125 depth	+/-0.010	.130	—			

Measured by:	OL
Date:	12/04/01

Audited by:	SL
Date:	12/04/02

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue	P/O D3610-041	KJ/DD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

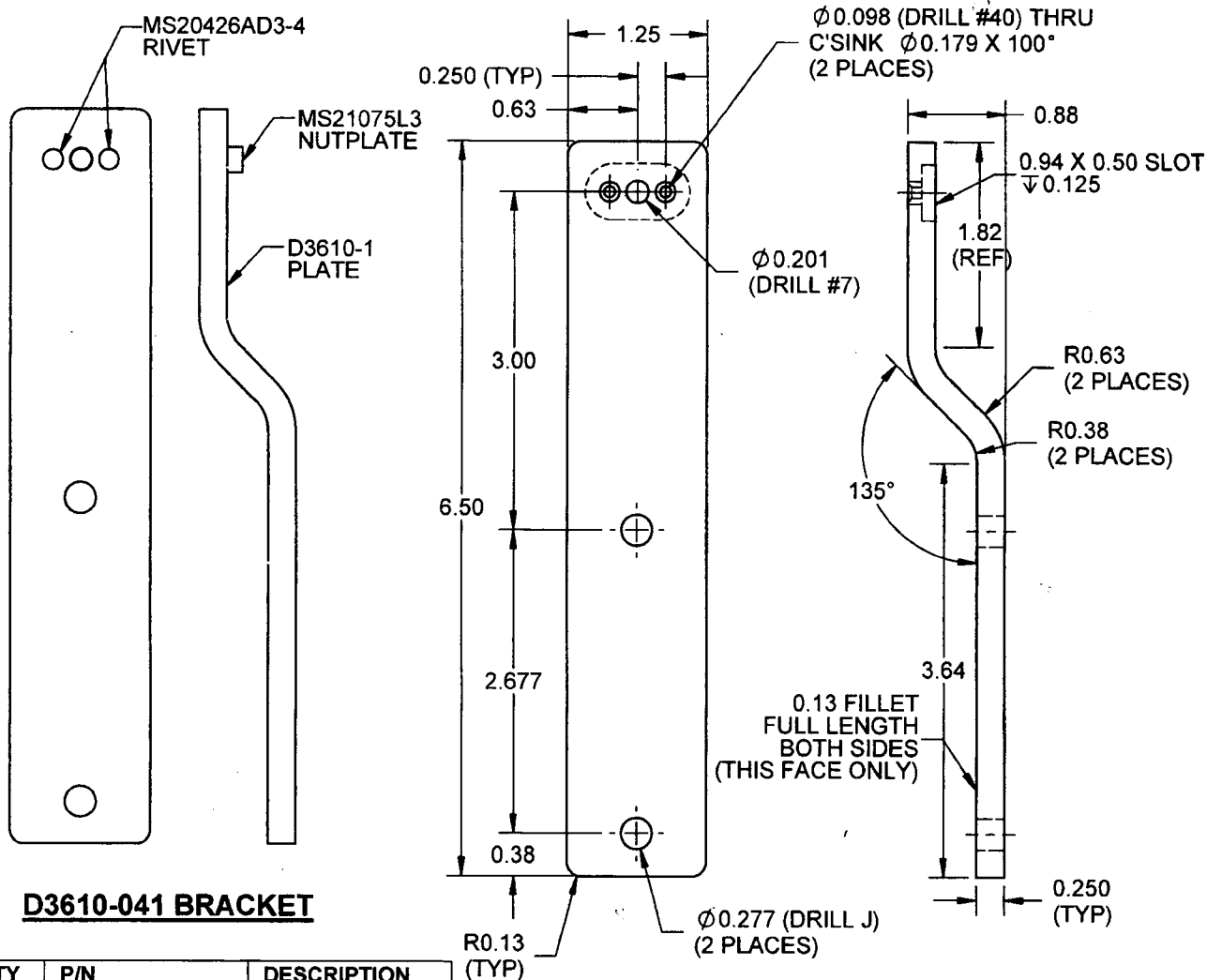
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20		TITLE BRACKET	SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

RELEASED

07.04.25 *[Signature]*

D3610-041 NOTES:

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Dart Aerospace Ltd

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 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries